

20-8705



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SCRAP

648.3540

Job Sheet 214795



Part No: 648.3540

Job Qty: 100 pcs

Part Name: Fwd Girt Strip



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/20

Job Tracking No:

Due Date: 11/25/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 648.3500 REV C IPP REV:A 20.11.02 NEW ISSUE FK VERIFY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	100 pcs		11/17/20	0.17	10.00	Waterjet - Omax		on 20/11/20
							Waterjet - Omax - SCH-S		
110	QC 2	100 pcs		11/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/11/20
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S311598



Part: 648.3540

Job No: 214795

Serial No/Batch: S311598

Revision: REV.C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/09/20

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
112	Small Fab - 2 - B4B	100 pcs	11/18/20	0.00 10.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
					Small Fab - SCH-B	
114	QC 5	100 pcs	11/18/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
					QC 5 - SCH-B	
120	NV5000 - 1 - B4B	100 pcs	11/24/20	1.00 100.00	NV5000 - 1 - B4B	
					NV5000 - 2 - B4B	
130	QC 2	100 pcs	11/24/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	

NOT REQUIRED

POSITIVE
RECALL70-11-20
acceptable603
11/09/2020
see attached
mz lend certs req'dDAS
82
9-89

NOV 09 2020

DIA / S.C.I.

20/11/9

debur & remove sharp edges

QC 2 - 30 11-11

						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 2 - 83	
140	QC 8	100 pcs	11/24/20	0.00	0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	Da 20-11-11
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
142	Small Fab - 2 - B4B	100 pcs	11/25/20	0.00	10.00	Small Fab - 1 - B4B	Smf
						Small Fab - 2 - B4B	20-11-11
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	

144	QC 5	100 pcs	11/25/20	0.00	0.00	Small Fab - 8 - B4B	
						Small Fab - 9 - B4B	
						Small Fab - Various 1 - B4B	
						Small Fab - SCH-B	
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	NOV 12 2020
						QC 5 - 61	DAS 40 9-89
						QC 5 - 81	
						QC 5 - 82	
						QC 5 - SCH-B	
150	Packaging 3-1 - Stock - B4B	100 pcs	11/25/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	DAS 69 9-89
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	NOV 12 2020
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	

11/2/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
160 QC 21 - SA	100 pcs	11/25/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - 1-Cut as per DWG. DWG. Rev: C PROG. Rev: C 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 112 - Mill holes chmfs as per DWG
 120 - 1-Machine as per folio FD412 FOLIO REV: AA DWG REV: C 2-Deburr
 130 - QC2- Inspect parts off machine FAI/FAIB
 140 - QC8- Inspect parts - second check
 142 - Score surface, before applying primer, using 40 GRIT sand paper.
 150 - Identify as per dwg & Stock Location: _____
 160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M301S16GA-H50	301 SS Sheet 1/2 Hard	6.9000 sf (.069 ea)	100-Waterjet - Omax - 1	<u>FM131143</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M301S16GA-H50	7	25	0

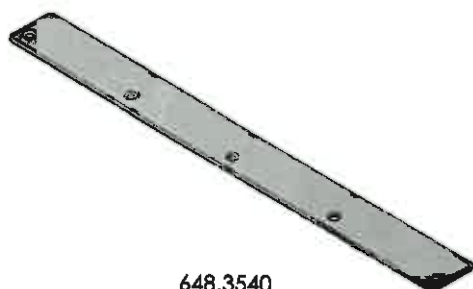
Part Specifications

Specifications could not be found.

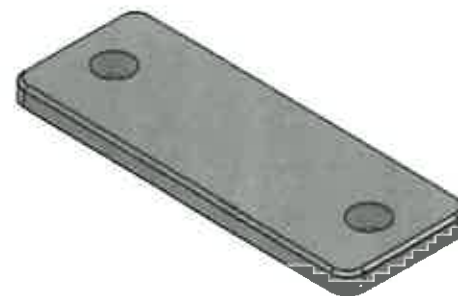
Plex 11/2/20 10:38 AM Dart.lajeunesse.marie

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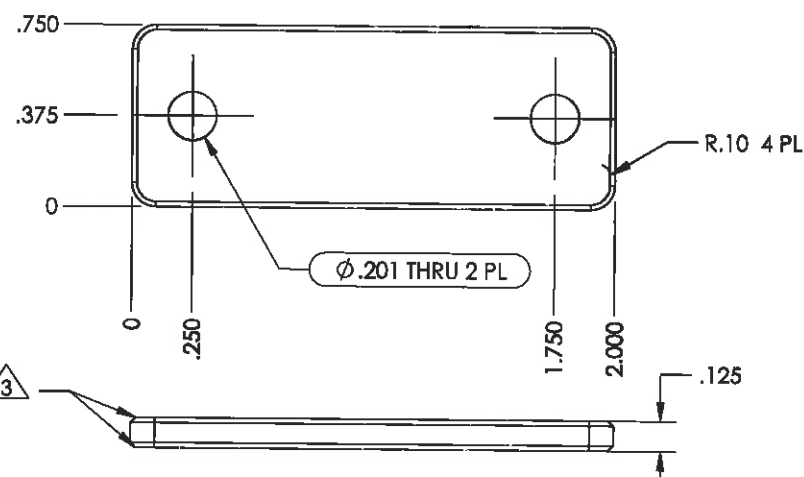
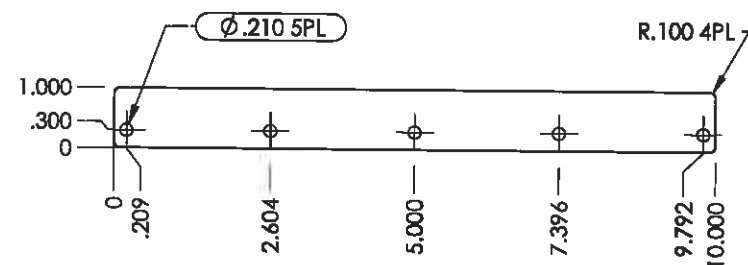
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 214795 MLJ
2011-02



648.3540



648.3545



.063

7 3

6 7

DETAIL A

ORIGINAL DATE 10/19/10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY B. ANDERSON	CHECKED P. BRAVO	SHEETMETAL	
DRAWING APPROVAL P. BRAVO 4-15-10	CONTRACTING	SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 2 OF 12	REV. C
SHEET B	CAGE CODE 07M26	DWG. NO. 648.3500	REV. C

ORDER NOTES

FAI measurements required for all parts on this order.
Lines 1-3 are priority.
Ship all lines Fedex Standard Overnight through account 198549495.

****CRITICAL REQUIREMENT TO DEBURR AND REMOVE SHARP EDGES****

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements.
Please visit www.dartaerospace.com for PO Terms & Condition and Quality Clause Standard Requirements for San Diego, CA, AIWI-7.4.1 QCS
PO order acknowledgement required.

All items/services subject to our inspection and acceptance.

Packing slip required with each shipment.

Certificate of

Conformity

is required.

Material and Outside Process Certifications required with each shipment

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

International / US Wires:

Swift Code: CHASUS33 Bank Routing #: 021000021 Account #: 133281000

Bank Name: JPMorgan Chase Bank 201 St. Charles Ave., New Orleans, LA USA 70170

Account Name: DART Aerospace Ltd.

Notification October 2018: Our banking information has remained unchanged

Latest Revision Provided Unless Otherwise Requested

Plex 10/30/20 1:32 PM [dart.crooks.caitlin](#)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER				ORDER					
Customer Code: CAPIC01 Sold To: DART Aerospace Ltd - Vista 3030 Enterprise Court, Suite A Vista, CA 92081 USA Phone: 760-509-1617 Ship To: DART Aerospace Ltd - Vista 3030 Enterprise Court, Suite A Vista, CA 92081 USA Phone: (760) 724-5300				Order No : 30757 Date: 10/29/20 Ship-To Contact: Ernle Navarro Email: enavarro@dartaero.com Cust PO No: POSD004481 FOB: Shipping Point Ship Via: Freight Terms: PrePaid Terms: Net 30 INCO Terms: Ex Works Order Taker: Tori Sera Order Taker Phone: Order Taker Email: tsera@dartaero.com					
Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	11/30/20	11/30/20	648.3535	Fwd RH Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all notes and flag notes onDWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES	50	pcs	\$38.96USD	pcs	\$1,948.10 USD
2	11/30/20	11/30/20	648.3538	Aft Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	25	pcs	\$14.62USD	pcs	\$365.41 USD
3	11/30/20	11/30/20	648.3539	RH Aft Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES	25	pcs	\$14.55USD	pcs	\$363.69 USD
4	11/30/20	11/30/20	648.3540	Fwd Girt Strip Build per DG /N648.3500 RevC. Adhere to allapplicable notesand flag noteson DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	100	pcs	\$10.28USD	pcs	\$1,028.10 USD
5	12/7/20	12/7/20	648.3537	Aft RH Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	25	pcs	\$10.09USD	pcs	\$252.26 USD
6	12/7/20	12/7/20	648.3536	Mid RH Girt Strip Build per DWGP/N 648.3500Rev C. Adhereto all applicablenotes and flagnotes on DWG. **CRITICALREQUIREMENTTO DEBURRAND REMOVESHARPEDGES**	20	pcs	\$38.96USD	pcs	\$779.24 USD
7	11/30/20	11/30/20	MISC	MISCELLANEOUS Non RecurringCharge-Programmingfor 648.3537,648.3538,648.3539 &648.3540	4	pcs	\$78.00USD	pcs	\$312.00 USD
8	11/30/20	11/30/20	MISC	MISCELLANEOUS Non-RecurringCharge-Programmingfor 648.3535 &648.3536	2	pcs	\$95.00USD	pcs	\$190.00 USD
								Sub Total	\$5,238.80 USD
								Grand Total	\$5,238.80 USD

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NOTES: UNLESS OTHERWISE SPECIFIED

1. DELETED
2. IDENTIFY IAW MPP-120
3. DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .015" TO .030" AROUND PART EXTERIOR EDGE
4. FINISH: BRUSHED
5. FINISH: IAW MPP-172 PRIMER IAW SECTION 4.2
6. DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .005" TO .010" AROUND PART EXTERIOR EDGE
7. 100% LOT INSPECTION, CRITICAL FEATURE
8. INSTALL F/N 17, JOINING F/N 13 OR 14 WITH F/N 5 IAW NAS1097AD3-5 SPECIFICATIONS
9. MASK INSIDE OF F/N 5 BEFORE APPLYING PRIMER.
10. MATERIAL: HALF HARD 301 STAINLESS STEEL PER AMS 5518.
11. SCORE SURFACE, BEFORE APPLYING PRIMER, USING 40 GRIT SAND PAPER
12. PRIMER FINISH: PC 4426, VENDOR: ROYAL ADHESIVES & SEALANTS
13. DIMENSIONS FOR FLAT PATTERN DRIVEN BY .DXF FILE
14. MATERIAL: P/N 600.0025, SEE SPEC AMS-021 REV B
15. MATERIAL: 316 STAINLESS STEEL PER AMS 5524
16. MATERIAL: 304 STAINLESS STEEL IAW 5640, 0.016" THICKNESS

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
NIC	LAST PROTOTYPING RELEASE PROOF	06-15-14	NIC
A	INITIAL RELEASE	09-04-14	P. BRAVO
B	INCORPORATED RCH 05570	02-02-18	P. BRAVO
C	INCORPORATED RCH 05587	03-24-20	J. GARDNER

		19	648.3548	DOOR PIN GUARD	13	
		18	648.3547	DOOR PIN GUARD	13	
12	12	17	601.3200	REDUCED CSK RIVET		NAS1097AD3-5
		16	648.3544	DOUBLER RUB STRIP	13	13
		15	348.3543	DOUBLER RUB STRIP	13	13
1		14	648.3542	RESERVOIR BRACKET DOUBLER	13	
	1	13	648.3541	RESERVOIR BRACKET DOUBLER	13	
		12	648.3540	FWD GIRT STRIP	13	13 13
		11	648.3539	AFT FLT RH GIRT STRIP	13	13 13
		10	648.3538	AFT FLT LH GIRT STRIP	13	13 13
		9	648.3537	AFT RH GIRT STRIP	13	13 13
		8	648.3536	MID RH GIRT STRIP	13	13 13
		7	648.3546	GIRT BACKING STRIP	13	13 13
		6	648.3545	GIRT BASE STRIP	13	13 13
6	6	5	651.0601	BUSHING ASSY		
		4	648.3535	FWD RH GIRT STRIP	13	13 13
		3	648.3534	AFT LH GIRT STRIP	13	13 13
		2	648.3533	MID LH GIRT STRIP	13	13 13
		1	648.3532	FWD LH GIRT STRIP	13	13 13
X		X	648.3506	BOTTOM AFT DOUBLER ASSY		5 9
	X	X	648.3505	TOP FWD DOUBLER ASSY		5 9
.3306	.3505	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

PARTS LIST			
NEXT ASSY (S)	ORIGINAL DATE (MM-DD-YY)	06-15-16	
648.3300	DRAWN BY	CHRIC BR	
	LANDING	P. BRAVO	
	DRAWING APPROVAL		
	CONTRACTING		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 3 PLACE DECIMALS ± .010 3 PLACE DECIMALS ± .005 ANGLES ± .5°		
SHEETMETAL		SHEET 1 OF 12	

DART 3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760)-724-5300
APICAL INDUSTRIES, INC.
DBA DART AEROSPACE

SHEETMETAL
SHEET 1 OF 12
SCALE NONE
REV C

Page: 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date / Recv Emp	PO U/M / Recv Qty	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-MET001 Metaux Castle									
PO26786	1		M30/S16GA	SF	12/23/2014	12/19/2014	30.0000	\$11.42	0.0000	0	\$342.65
CAD	No		301 88 SHEET PILE HARD	SF	30.0000	DCUSER		\$342.65	0.0000	0	
			m131143								
	2		71401-45		12/23/2014	12/19/2014	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT QUALITY CLAUSES		1.0000	DCUSER		\$0.00	0.0000	0	
			m131143								



Castle Metals®

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 1

Shipment No:2439217

Ship From: A. M. Castle & Co. MONTREAL - CASTLE METALS 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 18-DEC-2014	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2439217-2	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No 3666014	Line No 1	Item No 39877	Description 0.0630.SH.301.STAINLESS.1/2 HARD.36.0000.120.0000 SPECIFICATIONS: AMS 5518 Email P/s and certs to: clavoie@dartaero.com
Purchase Order No 26786		Part Number	Ordered Qty 1.00 PCS
			Invoice Qty 1.00 PCS

Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S FORWARD COPY OF P/S TO COLLEEN (MONTREAL) Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No. 119894676	Mill UNITED PERFORMANCE METALS	Heat Number 	Mech Id	PCS 1	Width (in) 36.0000	Length (in) 120.0000	Shipped Qty(LBS) 76.0000

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law is prohibited.	
We hereby certify the material covered by this certificate conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any special requirements as a part of the development. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 90 days of the shipment. Material cut to the correct size, or material not in the correct quantity cannot be returned for credit.	
Reviewed by: Anthony Castle Metals Representative	Date: Name: <i>[Signature]</i>

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D. Delaport 601 12 103 11 20 084 4485 6518
C. Xerox 7-63 14
Sung 4-184 22914
H. F 75623

Authorized Signatory

Lyme Harper

		AK Steel Corporation Metallurgical Test Report Coshocton Works 17400 State Route 16 Coshocton, OH 43912 U.S.A.		Page 1 Lot No. 867042 Ser No. 867042											
		MILL ORDER NO. 2720-245 PROCESSOR ORDER NO. 0102503 BUYER'S ORDER NO. 0102503 CAST NO. 1344 ENGLISH UNITS - PRODUCT - METRIC UNITS 36 IN DIA - 36,000 LBS COIL													
C S H I P T O	UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON, OH 45015		UNITED PERFORMANCE METALS O'NEAL PERFORMANCE METALS METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 45015												
	SCID ID	PIECE	HEAT	PARENT ID	NET WEIGHT										
	SKID0077	1	7542736	16017-02	2560 LBS. 12.25 KG.										
	TOTAL STRIPS	TOTAL PIECES			TOTAL NET WEIGHT										
	1	1			2560 LBS. 12.25 KG.										
L-Plate Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS															
ID	C	MN	P	S	SI	CE	NI	MO	N	CU					
7542736	.10	2.11	.023	.001	.50	0.02	0.11	.13	.003	.21					
SHIPPING DATE: 10/13/2014		REMARKS		THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A. (DIN EN 10225, 7031 & 7080 COMPLIANT). NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL. COILED PRODUCTS CONTAIN NO WELDS STEELMAKING PROCESS - EAF MELTED, AOD REFINED, CONTINUOUS CAST SLABS STAINLESS STEELS SUPPLIED BY AK STEEL CORPORATION COMPLY WITH THE EUROPEAN END-OF-LIFE VEHICLE DIRECTIVE 2000/54/EC (ELVD) AND THE RESTRICTION OF HAZARDOUS SUBSTANCES DIRECTIVE KNOWN AS EU-DIRECTIVE 2011/65/EU, EFFECTIVE JANUARY 3, 2013 (ROHS 2) RESIDUAL LEVELS OF Hg, Pb, Cd, & HEXAVALENT CHROMIUM ARE WITHIN ACCEPTABLE LIMITS ACCORDING TO THESE DIRECTIVES. AK STEEL HAS IMPLEMENTED, OPERATES AND MAINTAINS A QUALITY MANAGEMENT SYSTEM IN ACCORDANCE WITH THE REQUIREMENTS OF THE PRESSURE EQUIPMENT DIRECTIVE (PED) 97/23/EC 7/2, ANNEX 1, PARAGRAPH 4.7.											
UP000 AMS 5575M PE-12-14		PRODUCT DESCRIPTION CR 304 TYPE 301 STAINLESS HI 7.0% NID TR FINISH 1/2 HARD SLIT EDGE * 208 5518H * ASTM A 666-10 * MIL-S-5050 D-2HSD-3 CANCELED * G2-S-766-D (CANCELED) * UNS-530100 11TH EDITION * ASTM A 210-1C UNS 530100 CHROMIUM CANT * UNS-301-1/2HD 06-04-08 * PITNEY-BOWERS R2710 JAN 03													
*** CONTINUED ON NEXT PAGE ***															



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26786

Purchase Order Date 12/15/2014

PO Print Date 12/15/2014

Page Number 1 of 2

Order From : VC-MET001
METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - C/O 910720
P.O. BOX 4090 STN A
TORONTO, ON M5W 0E9
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 514 694 9575

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10177-2297
Terms Net 10
Currency CAD
FOB FCA (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	M301S16GA	301 SS SHEET 1/2 HARD	12/23/2014	FN	30.00	\$12.07	\$392.00
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MATERIAL: AISI 301 SS SHEET AS PER
MINIMUM 1/2 HARD 2B FINISH
AS PER AMS 5517 OR 5518, 5902, 5519 OR ASTM A665

MAT 19

Line Total: \$392.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	12/23/2014		1.00	\$0.00	\$0.00
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Procurement Quality Clauses
A005 RIGHT OF ENTRY
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

SP14-12-191

Note:

12/15/2014

Customer: COLLEGE H
Phone: 708-684-AMCS 5516
Fax: 708-684-AMCS 5516

Lynne Harper

				AK Steel Corporation Metallurgical Test Report Coshocton Works 17460 State Route 16 Coshocton, OH 43812 U.S.A.				Page 2																																																																																																			
				Load No. 0574042 Srm No. 0674042																																																																																																							
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THE PHYSICAL AND MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AND WERE MADE BY THE COSHOCTON WORKS OF AK STEEL CORPORATION.						THIS CERTIFIED TEST REPORT IS BEING ISSUED TO A CONSIGNEE OF MATERIAL FURNISHED FROM AK STEEL CORPORATION. TO PROVE THE PURCHASE OF ITS MATERIAL ON DELIVERY OF THE MATERIAL TO A THIRD PARTY IT MUST BE RE-CERTIFIED OR RE-ISSUED BY THE NAME OF THE CONSIGNEE.																																																																																																					
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Entered: LR Date: NOV 30 2020



NCR No. 20-8705

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>214 795</u> Part No. <u>648 3540</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date: <u>20-11-11</u>	Sequence #: <u>120</u>	QTY Affected: <u>1</u>	MRB (QSI042)	
Description Work Order Deviation		Disposition		
The part wasn't seated tight on the jig. the break edge is now a 0.050" 45° chamfer.		Scrap destroy no replace		
		Completed By <u>J.C.-L</u> <u>20-11-11</u>		
		Lead hand / Supervisor <u>A.A 20-11-11</u>		
		QC / QA Coordinator <u>PD 20-11-11</u>		
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☒ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:				